
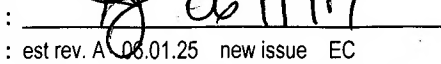


Date: Friday, 11/17/2006 9:08:08 AM  
User: Kim Johnston








# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : RIGHT ARM WELDMENT
<b>Job Number</b> : 29515	
<b>Estimate Number</b> : 12113	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D335311
<b>This Issue</b> : 11/17/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3353 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 27330	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 12/5/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : est rev. A 06.01.25 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010B1500X01500	MILD STEEL BAR 1.5 X 1.5
 		
<b>Comment:</b> Qty.: 0.2100 f(s)/Unit Total: 0.8400 f(s) 1010-1025 BAR AISI 1010-1025 Steel bar 1.50" x 1.50" Batch: <u>M16332</u> J.F. 06/12/03 (5)		
2.0	BAND SAW	BAND SAW
 		
<b>Comment:</b> BAND SAW Cut blanks 2.375" long J.F. 06/12/03 (5)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1  1-Machine as per Folio FA619 and Dwg D3353  2-Chamfer large hole manually per dwg D3353  2- Deburr J.F. 06/12/04 (4)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE J.F. 06/12/04 (4)		
5.0	QC8	SECOND CHECK
 		
<b>Comment:</b> SECOND CHECK J.G. 06/12/04 (4)		

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/04	3	1 piece is scrap because the chamfer 1030" x 45" is to big.		scrap and replace	J.F. 06/12/04			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:08:08 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 29515

Part Number: D335311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify & Stock (WS) 11/20/05 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/20/06 (4)

Job Completion



C 11/21/06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

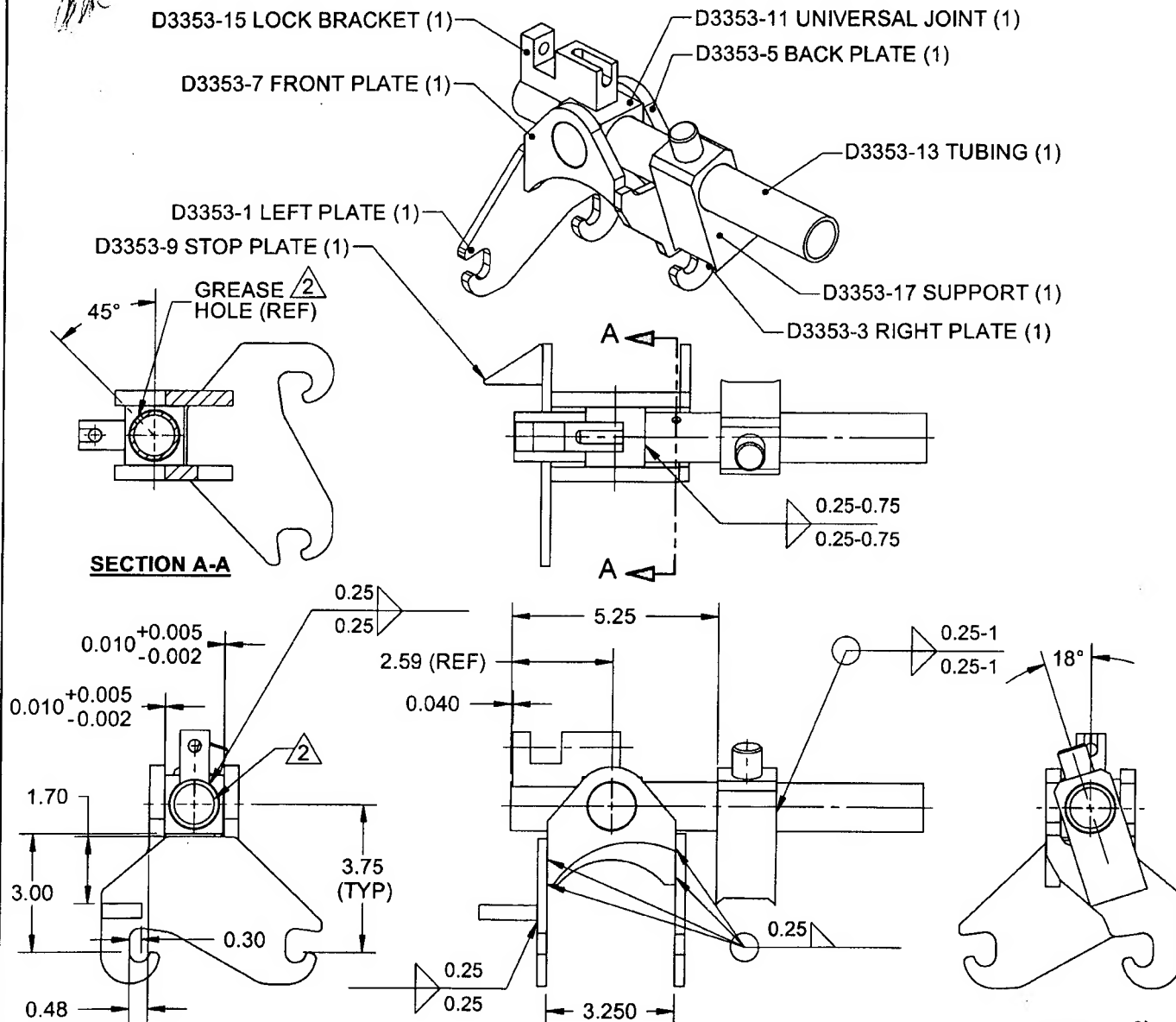
**NOTE:** Date & initial all entries





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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED  
04/12/14



### D3353-041 LUG WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3 WITHOUT NOTICE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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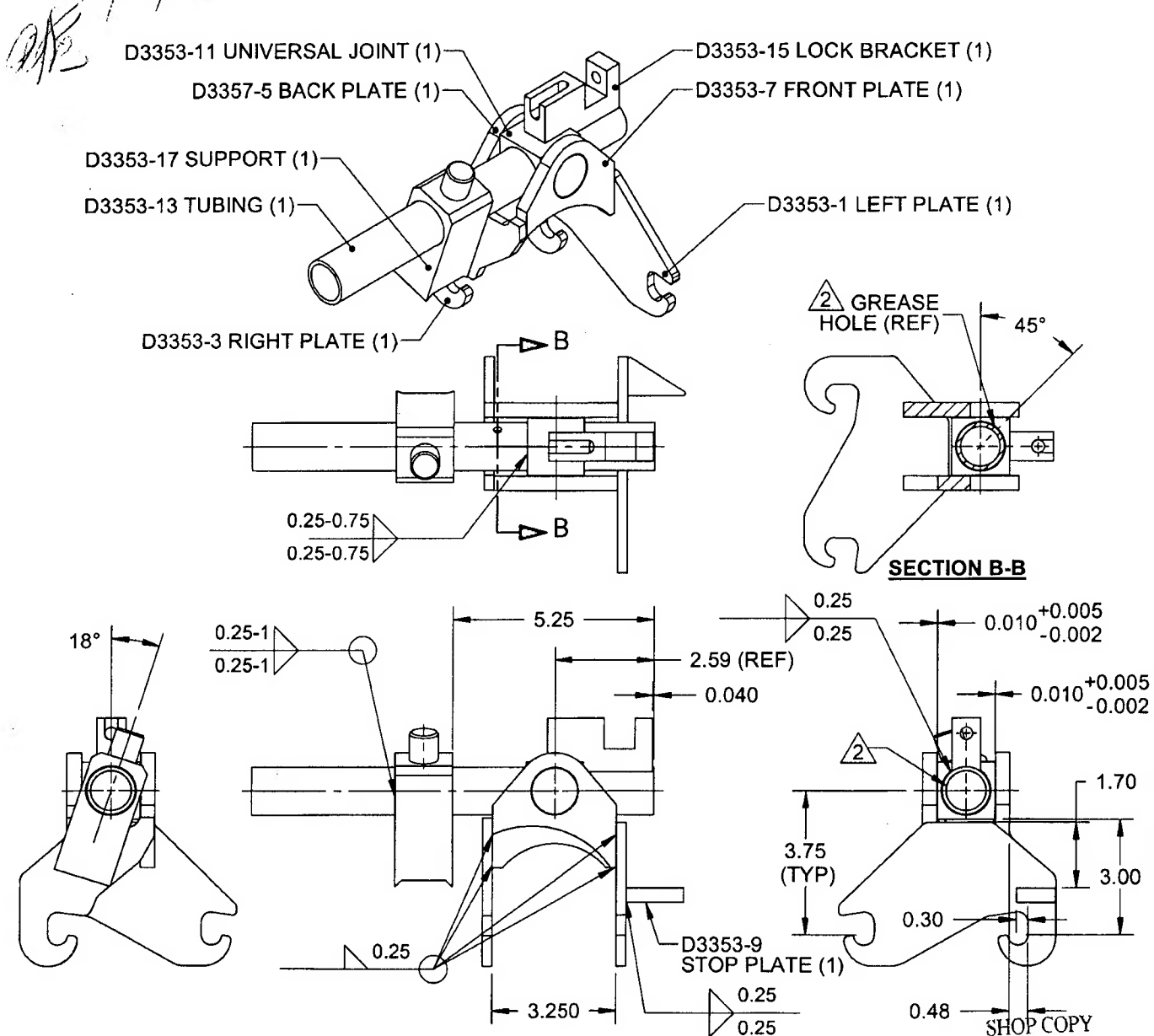
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06/03/59



### D3353-042 LUG WELDMENT

#### NOTES:

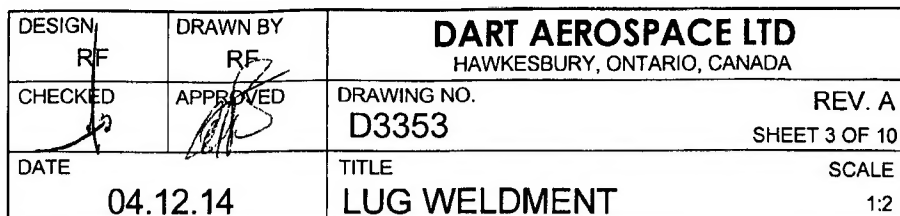
- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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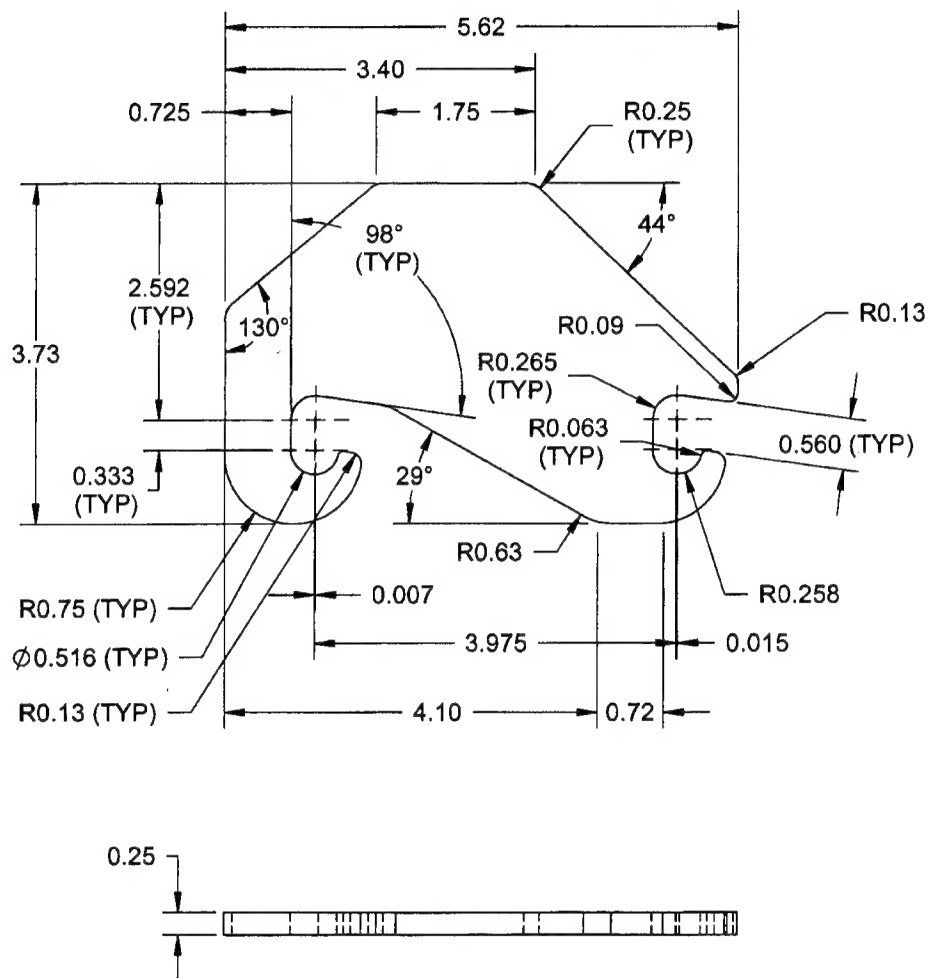
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1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK) WITHOUT NOTICE  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

WORK ORDER  
NO. 29515

WORK ORDER  
NO. 29515

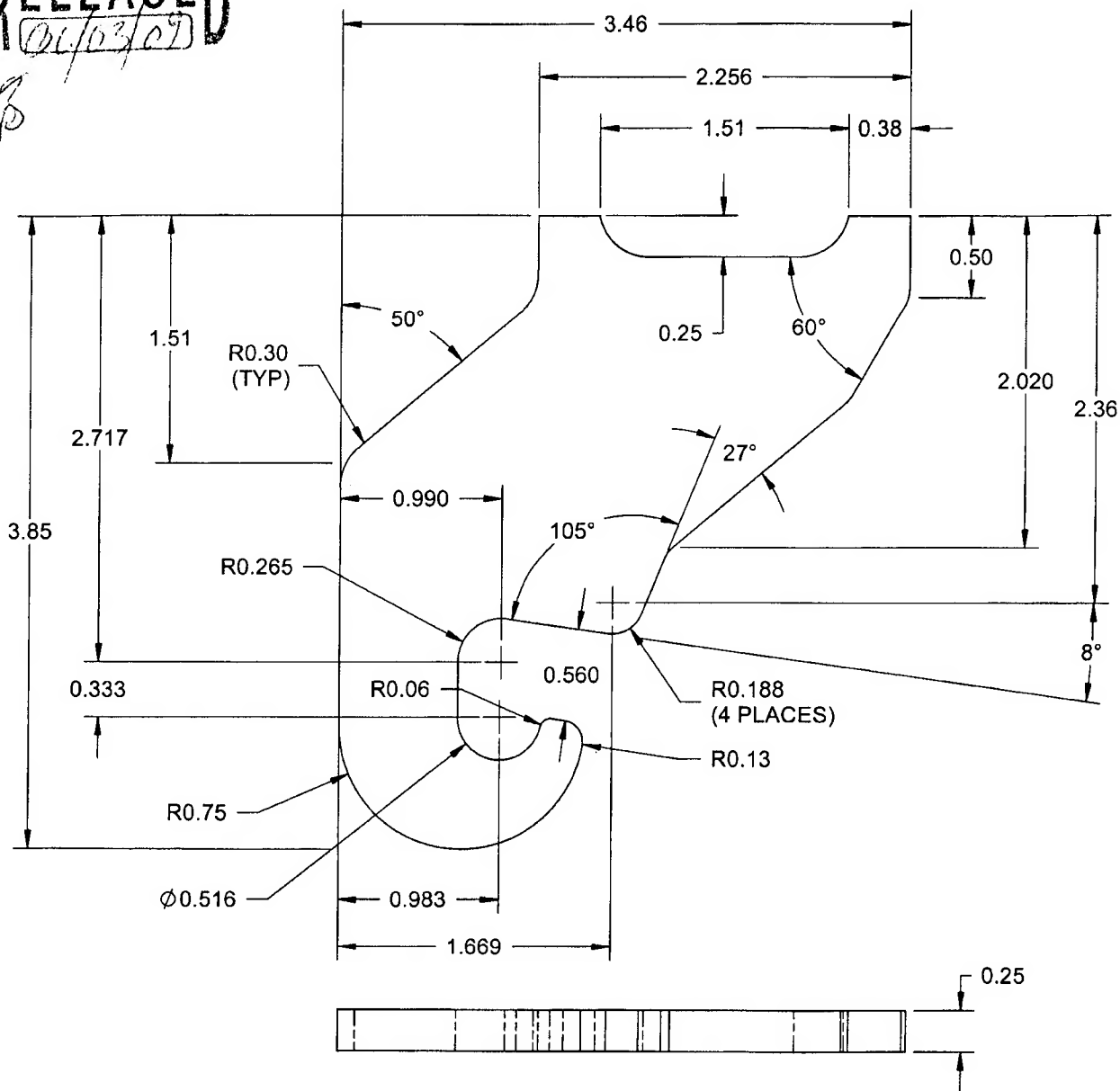
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**D3353-3 RIGHT PLATE**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

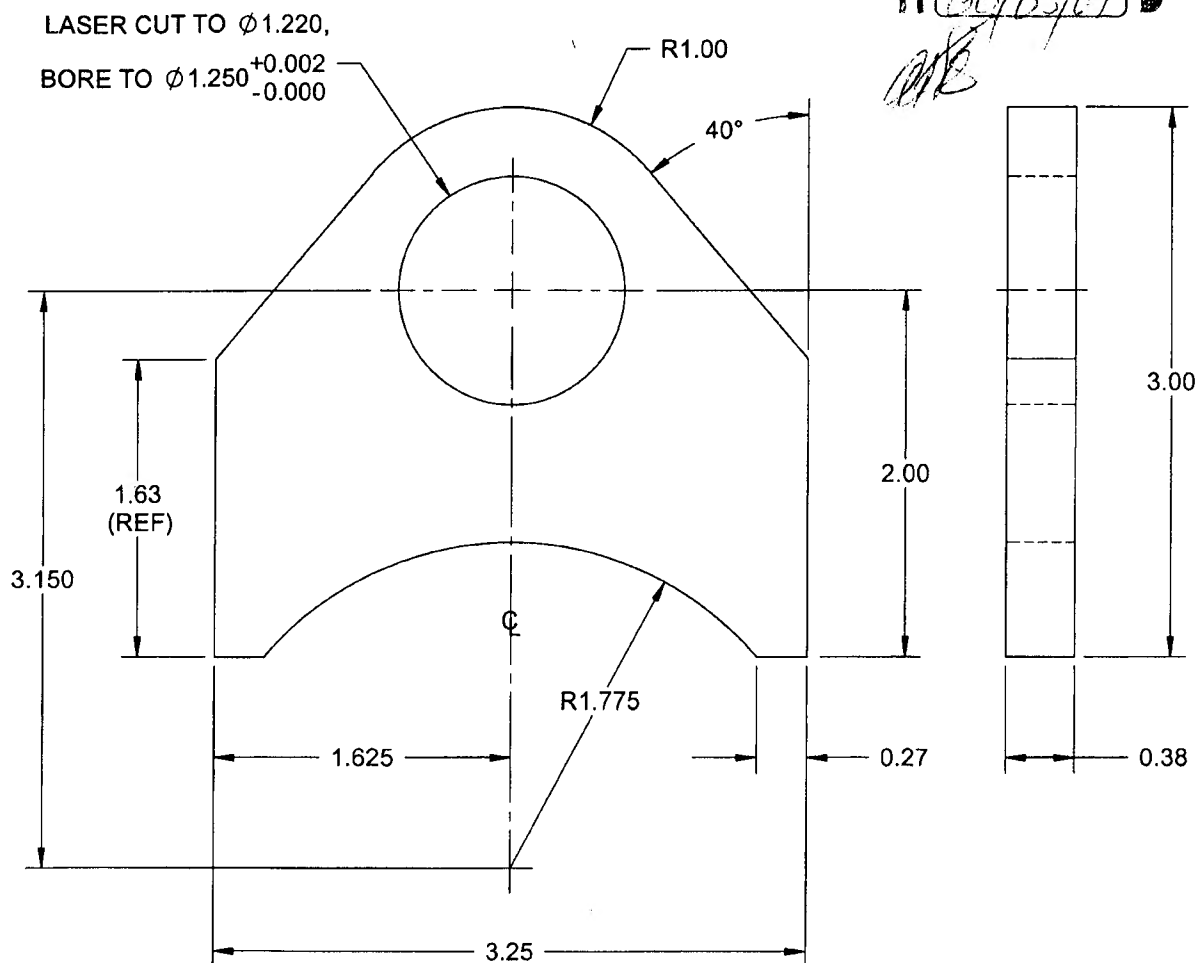
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**D3353-5 BACK PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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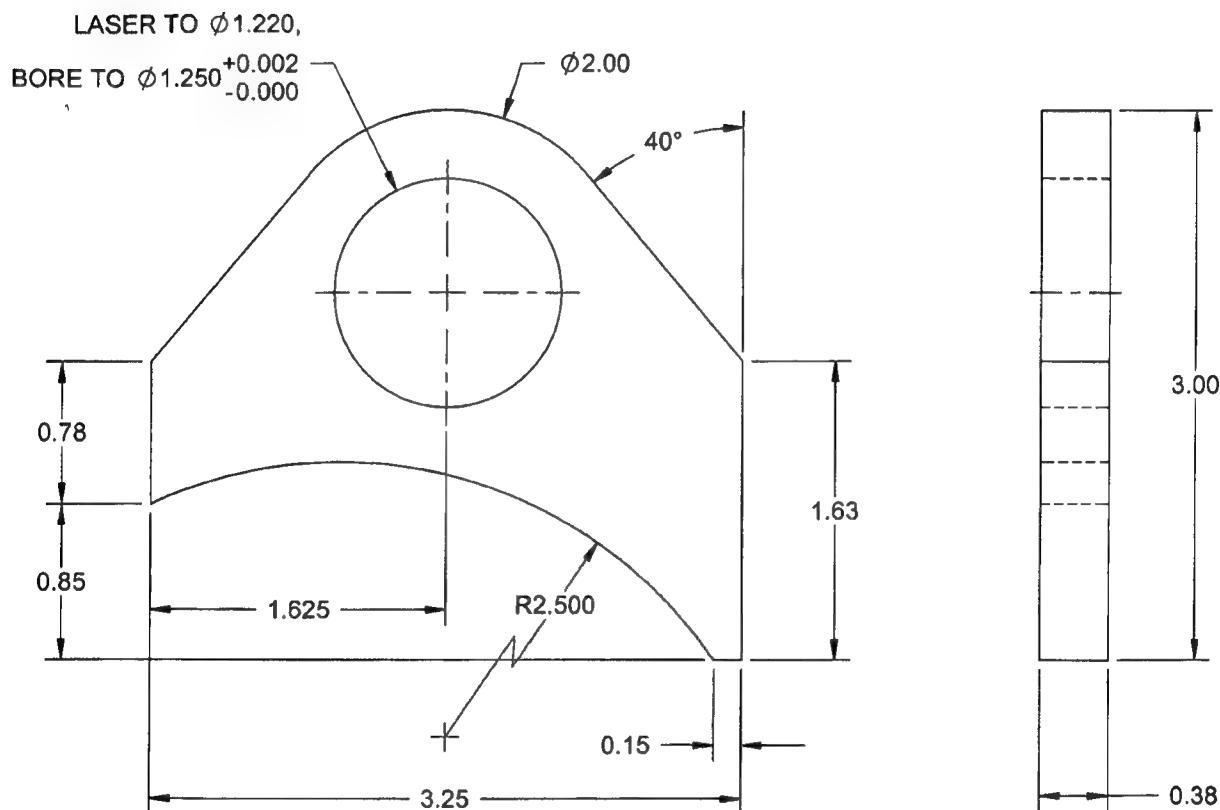
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### D3353-7 FRONT PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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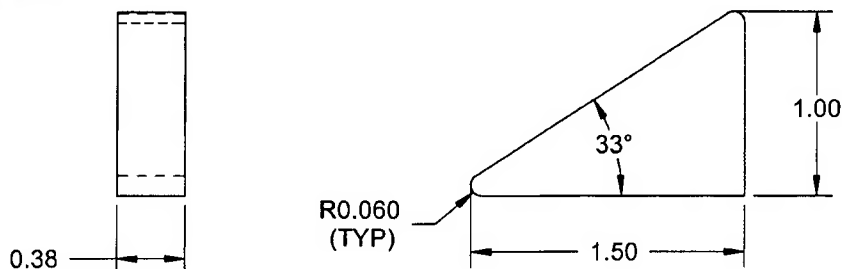
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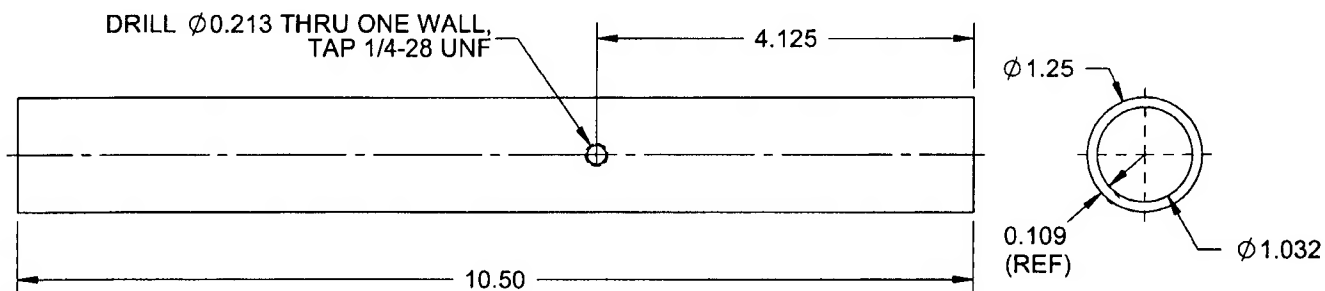
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### D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK  
MILD STEEL BAR (REF. DART SPEC. M1010-B)



### D3353-13 TUBING

#### NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,  
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING  
(REF. DART SPEC. M1020TR1.250W.109)

#### NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

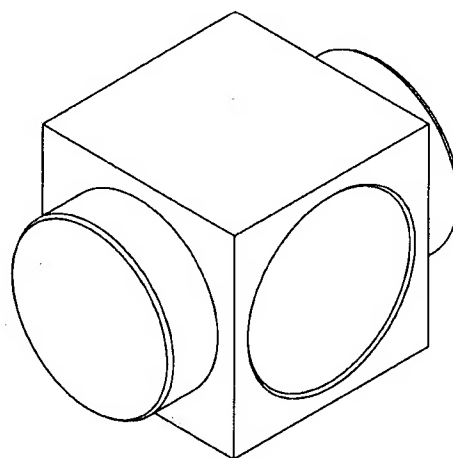
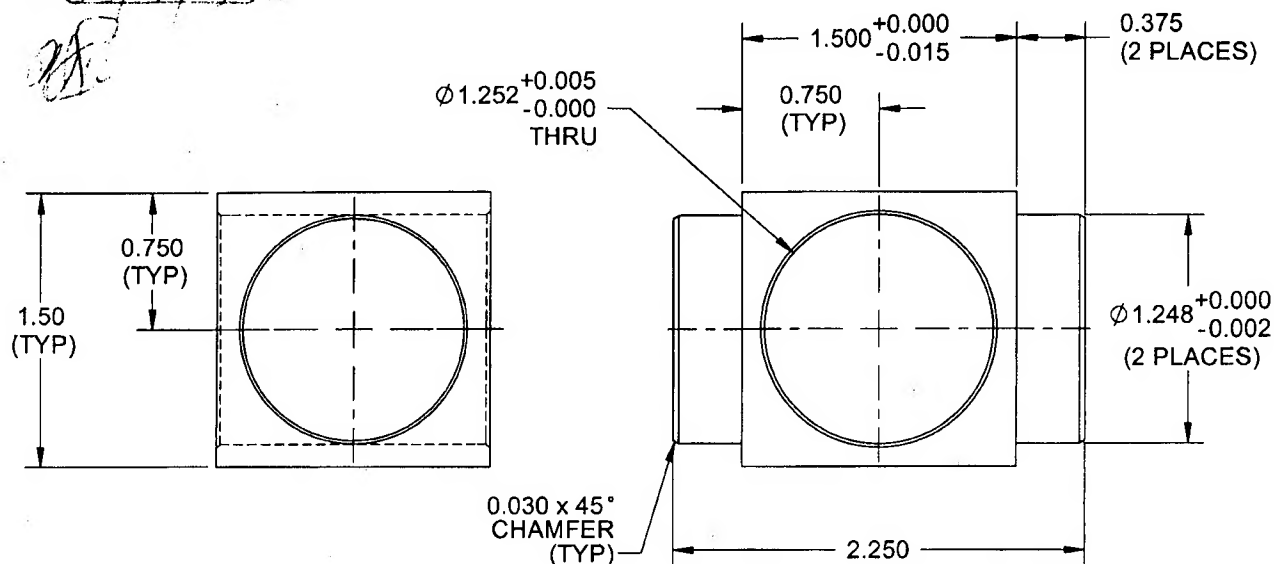
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04/30/14**D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

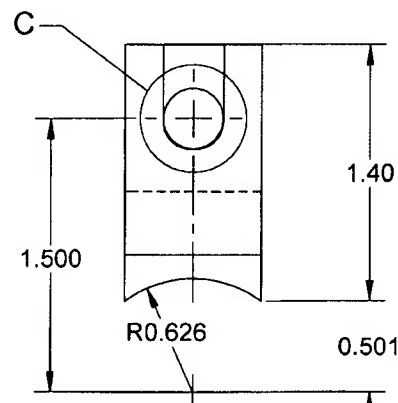
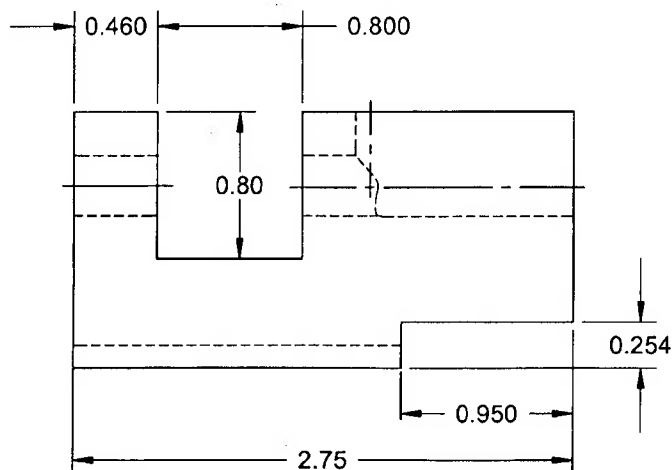
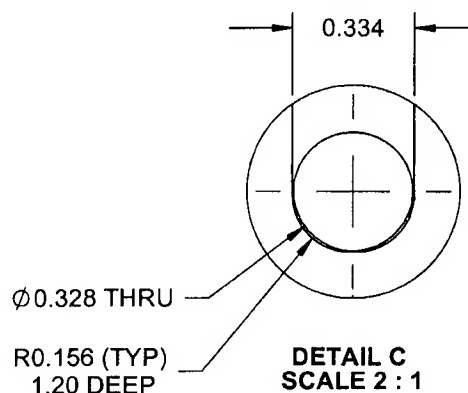
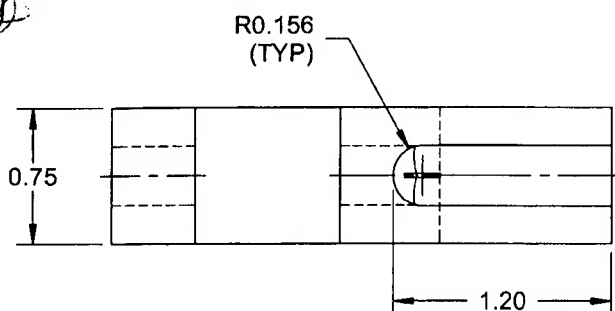
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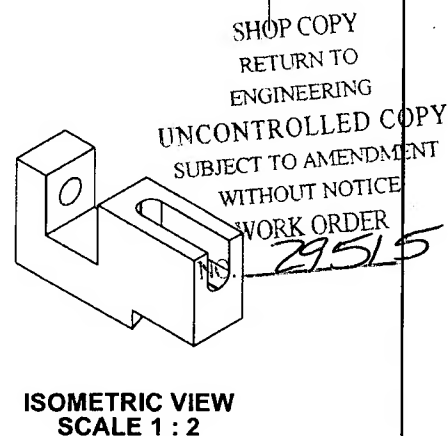
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**RELEASED**  
06/02/09**D3353-15 LOCK BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

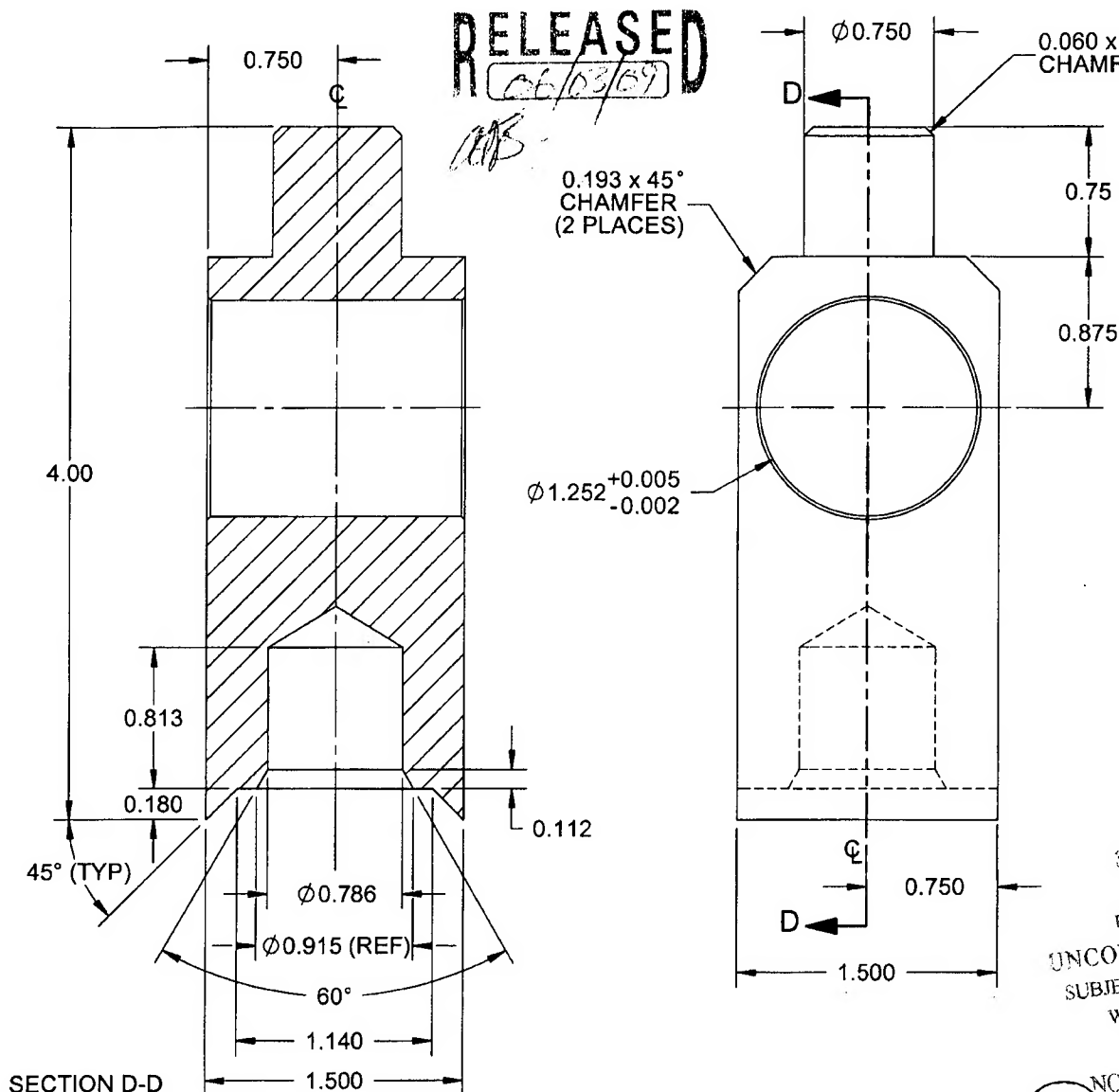


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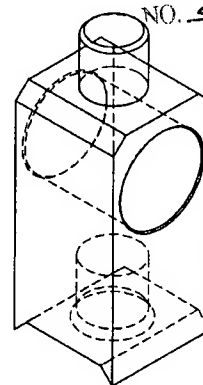
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**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
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